

Date: Friday, 25/07/2008 4:20:47 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET		
Job Number	: 40760		Part Number	: D21961		
Estimate Number	: 13512		Drawing Number	: D2196 REV C		
P.O. Number	:		Project Number	: N/A		
This Issue	: 25/07/2008	S.O. No. :	Drawing Revision	: C		
Prsh Rev.	: NC		Material	:		
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 20/08/2008	Qty:	2 Um: Each
Previous Run	:					
Written By	:					
Checked & Approved By	: <u>JUL 08 7.25</u>					
Comment	: Est Rev:A 08-07-24 new issue ec verified by:dd					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304S16GA	304/316 Sheet .063	
		Comment: Qty.: 0.2216 sf(s)/Unit Total : 0.4431 sf(s) 304 SS Sheet 0.063" thick batch: <u>108724</u> <u>FB 8-8-21</u>	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2196 Dwg Rev: <u>C</u> <u>FB 8-8-21</u> Prog Rev: <u>C</u>	(3)
		2-Deburr if necessary <u>FB 8-8-21</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	(3) 08/08/01 X3
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE	
		Bend as per dwg D2196	<u>SB 08/08/25</u> (3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 25/07/2008 4:20:48 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BRACKET
Job Number: 40760		Part Number: D21961
Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<i>S 08/08/05 (+3)</i>
7.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify with Dart part # using a fine point permanent marker and Stock Location: 18		<i>8/8/25</i>  <i>(6) 3X</i>
8.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		 <i>08/08/26 (+)</i>
Job Completion		 <i>6 08-28-26</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

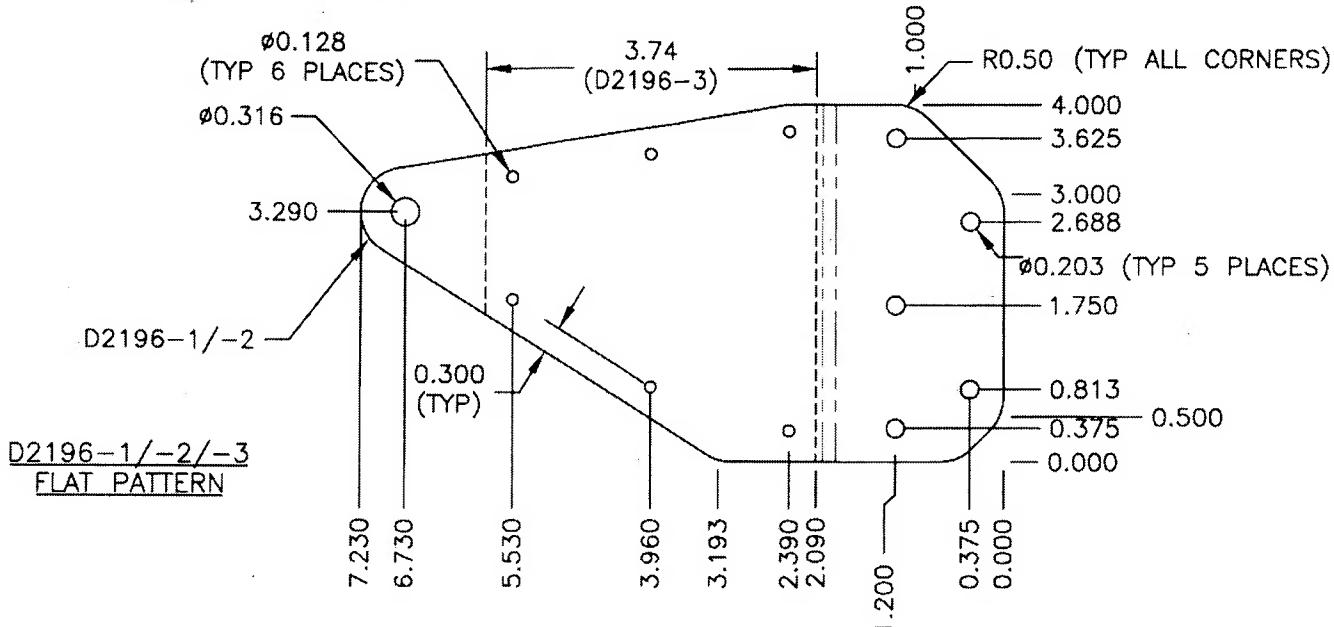
NOTE: Date & initial all entries

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2196	SHEET 1 OF 1
DATE	TITLE		SCALE
03.05.28	BRACKET		1:2
B	93.09.23	REDESIGN	
C	03.05.28	REDRAW; D2196-3 NOW 0.5" THICK	

03.05.28



D2196-1/-2

- 1) MATERIAL: AISI 304/316 S.S.
0.064" THICK (M304S16GA)

D2196-3

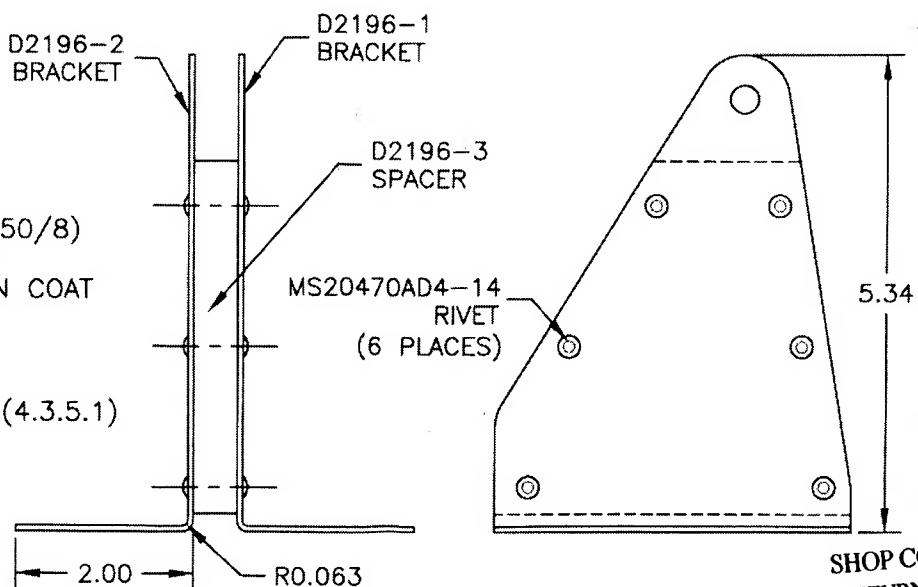
- 2) MATERIAL: 5052H32 (QQ-A-250/8)
0.500" THICK 4x0.125 THICK
- 3) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1

D2196 BRACKET (ASSEMBLY):

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)
PER DART QSI 005 4.3

GENERAL NOTES:

- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.015



D2196 BRACKET
(ASSEMBLY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40100

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DART AEROSPACE LTD	Work Order:	40760
Description: BRACKET	Part Number:	D2196-1
Inspection Dwg: D2196-1 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	Audited by:	Prototype Approval:
Date: 08-08-21	Date: 08/08/21	Date: 1/4

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

